

Work Order ID 112821

February-07-14 11:53:50 AM

SUB MOUNTY Feb. 10

112821

PRELIMINARY ISSUE

Page 1

Item ID: D4541-7

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bracket

Start Date: 2/07/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/10/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4541

D

100

0.00

100

Waterjet

FLOW CNC Waterjet

6061-032

Memo

0.00

1- Cut as per dwg D4541-7F

Prog rev: 2

Dwg rev: 2

2- Deburr

see attached
marked up drawing!

Prelim DXF

2

0

14.02.10

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Quality Control

Memo

0.00

2

0

14.02.10

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Quality Control

Smt
14/2/10

14/02/00

DAS
27
9-89

14/2/20

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Page 3

Item ID: D4541-7 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bracket
Start Date: 2/07/14 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 2/10/14 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
144	Chemical Conversion Coat per QSI005 4.1	0.00							
144	HandFinish	0.00				2	716	14-2-10	
Hand Finishing	Memo								
			DAS 27 9-89						
146	QC7-Inspect Chemical Conversion Coat	0.00							
146	QC	0.00				2			
Quality Control	Memo								
150	Identify as per dwg & Stock Location: _____	0.00							
150	Packaging	0.00							
Packaging	Memo								

ME
14-2-12 14-2-12

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Page 4

Item ID: D4541-7

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bracket

Start Date: 2/07/14

Start Qty: 2.00

2

Cust Item ID:

Required Date: 2/10/14

Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

*14-02-10**ME*
14-2-10

Picklist Print

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Page 1

Work Order ID: 112821

Parent Item: D4541-7

Parent Item Name: Bracket

Start Date: 2/07/14

Required Date: 2/10/14

Start Qty: 2.00

Required Qty: 2.00

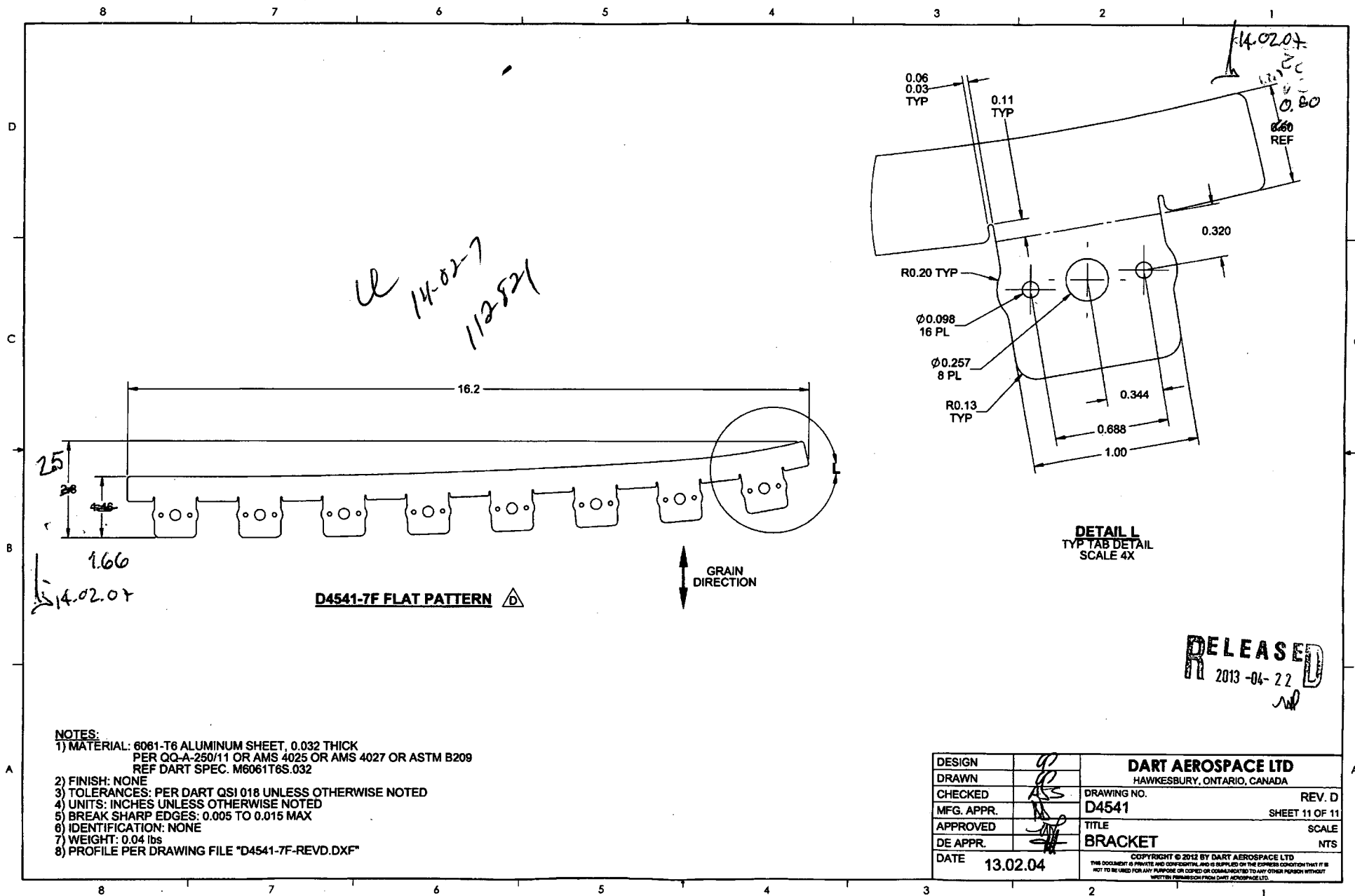
Comments: IPP revA 12.01.04 New Issue EC verified by:DD IPP REV:B 12.02.24 as per dwg
revb DD verf:EC IPP REV:C 12.05.08 as per dwg revC DD verf:EC IPP
REV:D 13.04.23 as per dwg revD DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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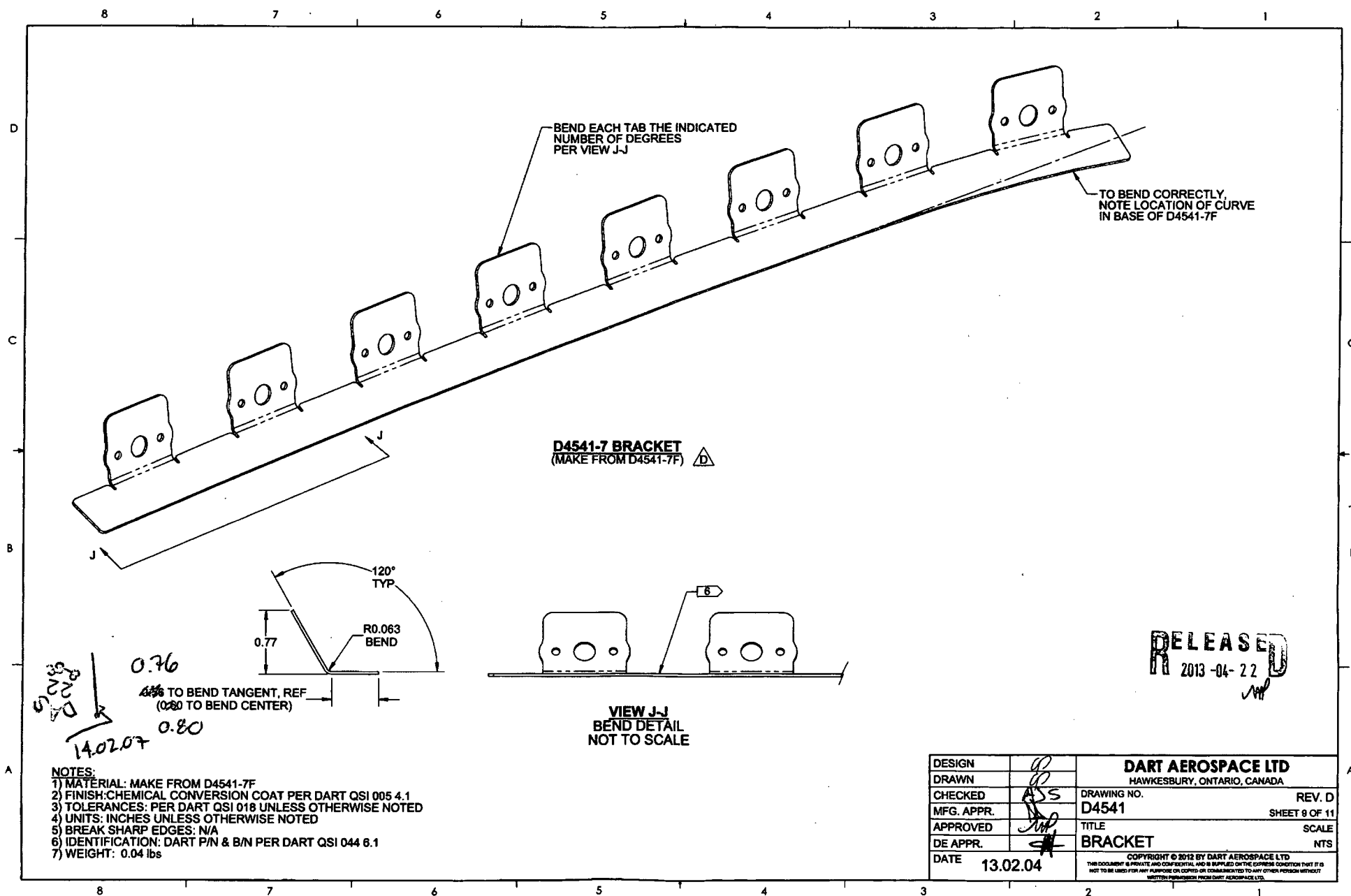
M6061T6S.032 6061-T6 Sheet 0.032"		Purchased	No			100	sf	473.3232	0.258	1		14.02.10	
--------------------------------------	--	-----------	----	--	--	-----	----	----------	-------	---	--	----------	--

Location	Loc Qty	Loc Code
MAT021	473.32317	
123483	8.57	
m125822	17	
m127272	129.75317	
m128054	318	

128054 → (i)



RELEASED
2013-04-22



Linda Lacelle

From: Marc Bellavance
Sent: February-07-14 11:50 AM
To: Linda Lacelle
Cc: Melanie Fauteux; Nigel Forbes
Subject: RE: Windshield Modification Kit Pn IIN-D206-817
Attachments: D4541-7F-REVD_CUSTOM.dxf

Sorry, DXF attached

From: Marc Bellavance
Sent: Friday, February 07, 2014 11:48 AM
To: Linda Lacelle
Cc: Melanie Fauteux; Nigel Forbes
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

Thanks Linda.
DXF attached; I'll hand you the marked up dwg shortly.

From: Linda Lacelle
Sent: Friday, February 07, 2014 11:37 AM
To: Marc Bellavance
Cc: Melanie Fauteux; Nigel Forbes
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

We can sure try

From: Marc Bellavance
Sent: February-07-14 11:29 AM
To: Linda Lacelle
Cc: Melanie Fauteux; Nigel Forbes
Subject: FW: Windshield Modification Kit Pn IIN-D206-817

Linda,

Assisting Bell Helicopters installing our SIWK... They don't have enough meat on them parts and as per attached, ends up with very poor edge distance.

Can we get custom made D4541-7/-8, qty(2) each, out the door by Monday afternoon?

I can provide the DXF later this afternoon and will have to know the batch numbers for the no charge.

Marc

From: Boatright, Billy [<mailto:bboatright@bh.com>]
Sent: Thursday, February 06, 2014 4:24 PM
To: Marc Bellavance
Cc: Van Fleet, David; David Shepherd; Stelzig, Alan
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

Hi Marc

We have some things to report as shown in the photos.

The pic of the retainer 4543-5 is one we received today, not enough room the screw head.

We haven't had time to see if the other retainers fit any better.

Will talk to you tomorrow .

Thanks

Sr. Lead Inspector

Bill Boatright

Six Sigma Greenbelt



423-538-5111 Fax 423-538-8469

bboatright@bh.com

Bell Helicopter
A Textron Company

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From: Marc Bellavance [mailto:mbellavance@dartaero.com]
Sent: Tuesday, February 04, 2014 9:44 AM
To: Boatright, Billy
Cc: Van Fleet, David; David Shepherd
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

Bill,

The retainers are manufactured from 6061-T6 aluminum sheet, 0.032" thick.

Marc Bellavance
Technical / Shop Support

DART AEROSPACE
T 1 613 632 5200 > 243
M 1 613 676 0992
F 1 613 632 9311
S marcbellavance
www.dartaerospace.com



Technical Publications: Verify Revision Status/Download [HERE!](#)

From: Boatright, Billy [mailto:bboatright@bh.com]
Sent: Tuesday, February 04, 2014 9:33 AM
To: Marc Bellavance; David Shepherd
Cc: Van Fleet, David
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

Do you know what the final material is for the retainers ?
ie 7075 T3 ?

Sr. Lead Inspector

Bill Boatright

Six Sigma Greenbelt



423-538-5111 Fax 423-538-8469

bboatright@bh.com



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From: Marc Bellavance [<mailto:mbellavance@dartaero.com>]
Sent: Monday, February 03, 2014 4:39 PM
To: Boatright, Billy
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

Thanks Bill.

Marc Bellavance
Technical / Shop Support

DART AEROSPACE
T 1 613 632 5200 > 243
M 1 613 676 0992
F 1 613 632 9311
S marcbellavance
www.dartaerospace.com



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From: Boatright, Billy [<mailto:bboatright@bh.com>]
Sent: Monday, February 03, 2014 4:30 PM
To: Marc Bellavance
Subject: FW: Windshield Modification Kit Pn IIN-D206-817

FYI

Sr. Lead Inspector

Bill Boatright

Six Sigma Greenbelt



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bboatright@bh.com

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From: Boatright, Billy
Sent: Monday, February 03, 2014 4:27 PM
To: 'Peggy McDonald'
Cc: Van Fleet, David; Stelzig, Alan; David Shepherd
Subject: RE: Windshield Modification Kit Pn IIN-D206-817

To all

So far we not had much luck with -6 retainer ,we will try -4 in AM.
It's too much shrink & expand in a short area.

Sr. Lead Inspector

Bill Boatright

Six Sigma Greenbelt



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bboatright@bh.com

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From: Peggy McDonald [<mailto:pmcdonald@dartaero.com>]
Sent: Monday, February 03, 2014 8:42 AM
To: Boatright, Billy
Cc: Van Fleet, David; Stelzig, Alan; David Shepherd
Subject: RE: Windshield Modification Kit Pn IIN-D206-817
Importance: High

Good Morning Billy,

How does a call at 1:00 today work for you? I am located just outside of Mirabel, so I believe we are on the same time zone.

David Shepherd, our VP of Engineering, whom some of you may have met previously, will be on the call to provide technical support.

Once, I have your confirmation that this time is suitable, I will send an meeting request with call in numbers. We await your reply.

Kind regards
Peggy

Peggy McDonald
Sales Account Executive

DART AEROSPACE
T 1 613 632-3336 > 260
M 1 613 676-1710
F 1 613 632-4443
S pmcdonalddhs1
1 800 556-4166
www.dartaerospace.com



From: Boatright, Billy [<mailto:bboatright@bh.com>]
Sent: Friday, January 31, 2014 10:59 AM
To: Peggy McDonald

Cc: Van Fleet, David; Stelzig, Alan

Subject: Windshield Modification Kit Pn IIN-D206-817

Peggy

Attached are photos of one of the issues we talked about.

Things can wait until Monday for a conference call , we do have some time so maybe you will be able to send someone down to help us through the first one.

My Cell #423-502-5860

Dave Van Fleet # 423-213-0759

Sr. Lead Inspector

Bill Boatright

Six Sigma Greenbelt



423-538-5111 Fax 423-538-8469


bboatright@bh.com

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INSPECTION SHEET

Measured by: DAS 30 9-89	Checked By:  Date: 10-02-14	QC inspector: DAS 27 9-89 Date: 11/2/10	Engineering Approval (if necessary): Date:
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